

Work Order ID 161705

Tuesday, May 23, 2017 9:31:28 AM

161705

Page 1

Item ID: D206-739-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aircraft Disabling Device

Start Date: 5/30/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/2/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **MAY 23 2017**

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev N/A

DAS 6 9-89**MAY 30 2017**

100	Document Control	0.00
100	DOCUMENT CONTROL	
DC	Memo	0.00
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-739-011CHG002	

DAS 28 9-89**MAY 31 2017**

110	Pick Kit	0.00
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110

Packaging	Memo	0.00
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Packaging

DAS 26 9-89**DAS 27 9-89****MAY 30 2017**

120	QC4- 100% Inspect kits for completeness	0.00
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120

QC	Memo	0.03
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Quality Control

Ensure that keys can be locked and unlocked for each D3370-041 and D3393-041 assembly.

DAS 28 9-89**MAY 30 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

161705

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N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 5/30/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/2/2017 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location:

0.00

130

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D206-739-

011 Location: Ps 121 PPP Rev: _____
Numbers For The Following: D3370-041
041

Record Key
D3393-

DAS
28
1-89

MAY 31 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

Memo

0.10

QC

Quality Control

DAS
21
9-89

MAY 31 2017

DAS
21
9-85

MAY 31 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, May 23, 2017 9:31:26 AM

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Work Order ID: 161705

161705

Parent Item: D206-739-011

D206-739-011

Parent Item Name: Aircraft Disabling Device

Start Date: 5/30/2017

Required Date: 6/2/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E Re-Format 05-11-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3370-041

Manufactured

No

120

Each

2.0000

1

1

D3370-041

Tail Rotor Pedal Lock

**

DAS
26
9-89
DAS
27
9-89

Location

Loc Qty

Loc Code

ST497

2

145460

1

155683

1

1x.

MAY 30 2017

D3393-041

Manufactured

No

120

Each

4.0000

1

1

D3393-041

Battery Lock

**

DAS
26
9-89
DAS
27
9-89

Location

Loc Qty

Loc Code

ST501

4

155320

1

159044

3

1x.

MAY 30 2017

DAS
28
9-89

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		☐ OTHER :							

3.4.2 Connect the plug to the battery terminal in the battery case. Ensure proper engagement.

3.4.3 Latch the door of the battery compartment.

4.0 PARTS LIST

-013	-011	Part Number	Description
	X	D206-739-011	DUAL DISABLING KIT
X		D109-739-013	DUAL DISABLING KIT
	1	D3370-041	TAIL ROTOR PEDAL DISABLING KIT
1		D4593-041	TAIL ROTOR PEDAL DISABLING KIT
	1	D3370-051	* PEDAL LOCK ASSEMBLY
1		D4593-051	* PEDAL LOCK ASSEMBLY
1	1	D3384-041	* CYCLIC SOCK
1	1	HX-81	* 1/4" -20 SOCKET HEAD CAP SCREW
2	2	AN960-416	* WASHER
1	1	D3373-5K	** KEY, REPLACEMENT
1	1	D3393-041	BATTERY DISABLING KIT
1	1	D3373-1K	** KEY, REPLACEMENT

* shown for reference only, part is included in D3370-041/D4593-041 assembly above

** shown for reference only, p/n for ordering replacement keys

Quality Control

Ensure that keys can be locked and unlocked for each D3370-041 and D3393-041 assembly.